

170 05/20

DART AEROSPACE LTD

Work Order:

23103

Description: Aft Crosstube Extended Height Gear (-013)

Part Number:

D205-596-107

Drawing: D205-596-107 Rev. A

Qty:

1

Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveller Dwg not required	HA	05-01-27	1
2	DC	Photocopy D205-594 bluefile & type labels per PPP D205-596-107 CHG001 WK 18	HA	05-05-03	1
3	LG	Bend D2890 as per Dwg D2890 and Folio FT002 Pick: Qty Part number Description Batch 1 D2890 Aft Crosstube B22534	DP	05-11-27	1
4	QC6	Inspect dimensions per Dwg D2890	HA	05-11-29	1
5	LG	Deburr and Polish			
6	FP	Acid etch and alodine inside and outside of tube as per QSI 005 4.1	DP	05-11-28	1
7	QC5	Inspect work to Step 6	DP	05-11-28	1
8	LG	Mark 20.36" for cutting from tangential line in the straight section from D2890 as per Dwg wall template.	DP	05-12-15	1
9	QC6	Inspect dimensions. Conformity check and sign off by engineering.	DP	05-12-15	1
10	LG	Cut as per Dwg D205-596-107	DP	05-12-15	1
11	LG	Deburr & Inspect for surface damage. Polish cut surface. Scribe part # and batch # on one end of tube.	DP	05-12-16	1
12	FP	Touch up ends of the tube with Chemical Conversion Coat per QSI 005 4.1	DP	05-12-21	1
13	QC5	Inspect work to Step 12	DP	05-12-22	1
14	FP	Prime inside and outside with Immron per QSI 005 4.2	DP	05-12-23	1
15	QC14	Inspect Spray paint	DP	05-12-28	1
16	LG	Install abrasion strips per QSI 035 position using DT8582. Install supports and clamps per Dwg D205-596-107. Torque clamps to 80-100 in lb. Seal edges of support using Sikaflex. Pick: Qty Part number Description Batch 2 D2856-600-1009 Abrasion Strip B24328 2 D2940-1 Support B23233B 4 MS21920-28 Clamp M18433	DP	06-01-05	1
17	QC5	Inspect work to Step 16	DP	06-01-05	1
18	PK	Identify and pack for shipping as per PPP D205-596-107	DP	06-01-06	1
19	AC	Cost / Part:	DP	06-01-06	1
20	DC	Close W/O Inspect level 21	DP	06-01-08	1

Rev	Date	Change	Revised by	Approved
A	02.01.10	New Issue	NG/EC	
B	02.11.11	Re-format; D2890 was D6008-180	KJ	
C	02.12.11	Modified Steps 4 and 12	KJ/RF	
D	05.03.21	Added bending procedure	KJ/JLM	

RELEASED
05-01-27

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

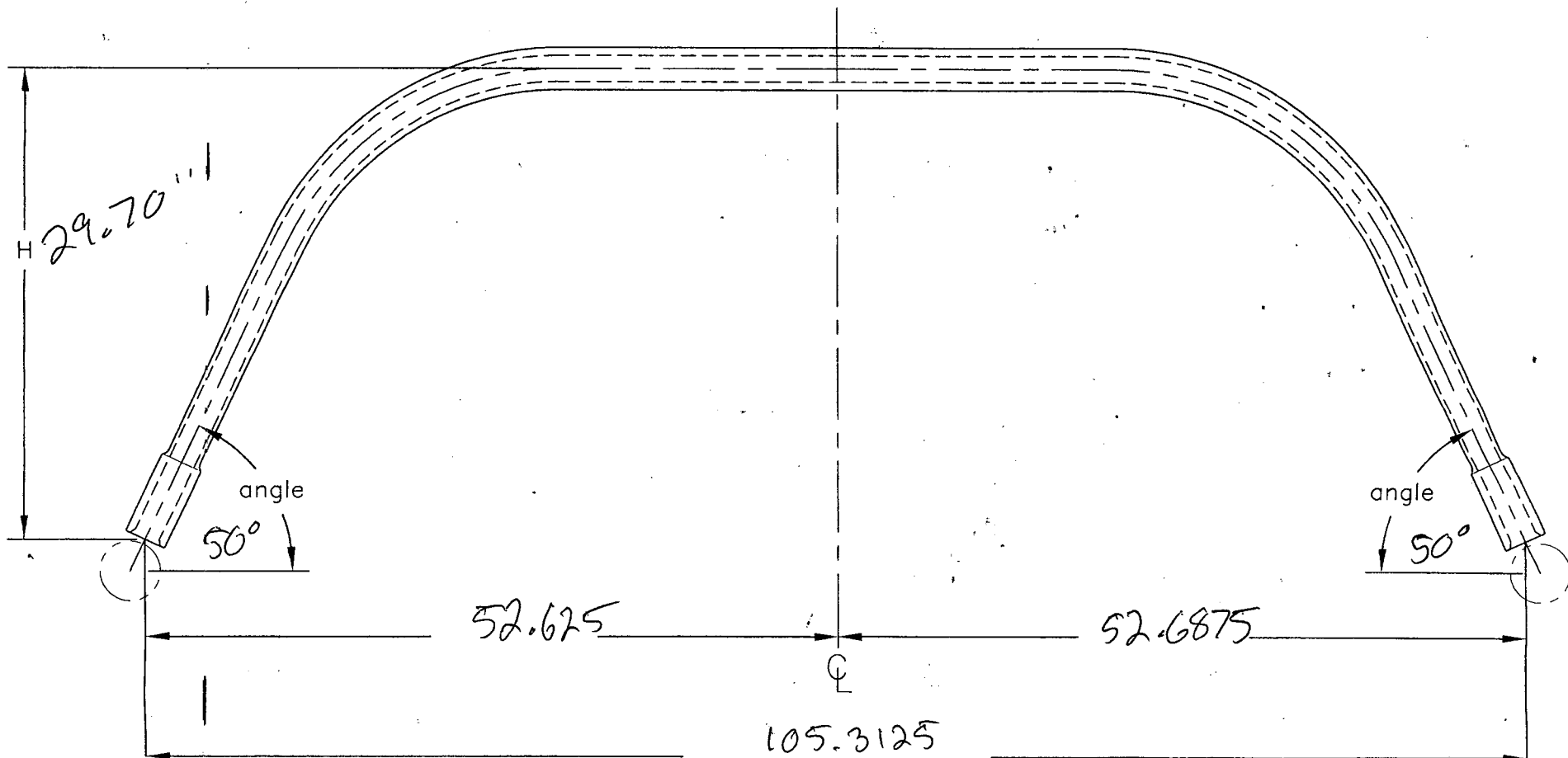
Apr 26, 2005
04:06 pm

Work Order No : 0023103
Project Name : D205-596-107
Project For : WK520
Work Order Type : Main
Main WO Number :
House Part Number : *D205-596-107
Description : Crosstube Aft Extended
Manufactured : Yes
Amount Req'd : 1
Amount Done : 0
Start Date : 04-26-05
Est Finish Date : 05-12-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Mark Up : 0.000%
Actual Mark Up : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	0.00	0.00	0.00	0.00	0.00
Engineering Hours	0.00	0.00	0.00		
Engineering Cost	0.00	0.00	0.00	0.00	0.00
Production Hours	0.00	0.00	0.00		
Production Cost	0.00	0.00	0.00	0.00	0.00
Packaging Hours	0.00	0.00	0.00		
Packaging Cost	0.00	0.00	0.00	0.00	0.00
OverHead Hours	0.00	0.00	0.00		
OverHead Cost	0.00	0.00	0.00	0.00	0.00
CNC Hours	0.00	0.00	0.00		
CNC	0.00	0.00	0.00	0.00	0.00
Misc. Hours	0.00	0.00	0.00		
Misc.	0.00	0.00	0.00	0.00	0.00
Burden	0.00	0.00	0.00		
Total Cost	0.00	0.00	0.00		
Mark up	0.000	0.000			
Selling Cost	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	0.00	0.00
Profits/(Loss)	0.00	0.00



DATE: 05-12-15

DESCRIPTION: 205-596-107

BATCH NO: 23103

DRAWING: 205-596-107 Rev A

H: 29.80"

1/2 SPAN: 52.5"

TOTAL SPAN: 105.0'

ANGLE: 50° + 2/-1

M. G. for

Final cut Height 30.7" 05-12-15

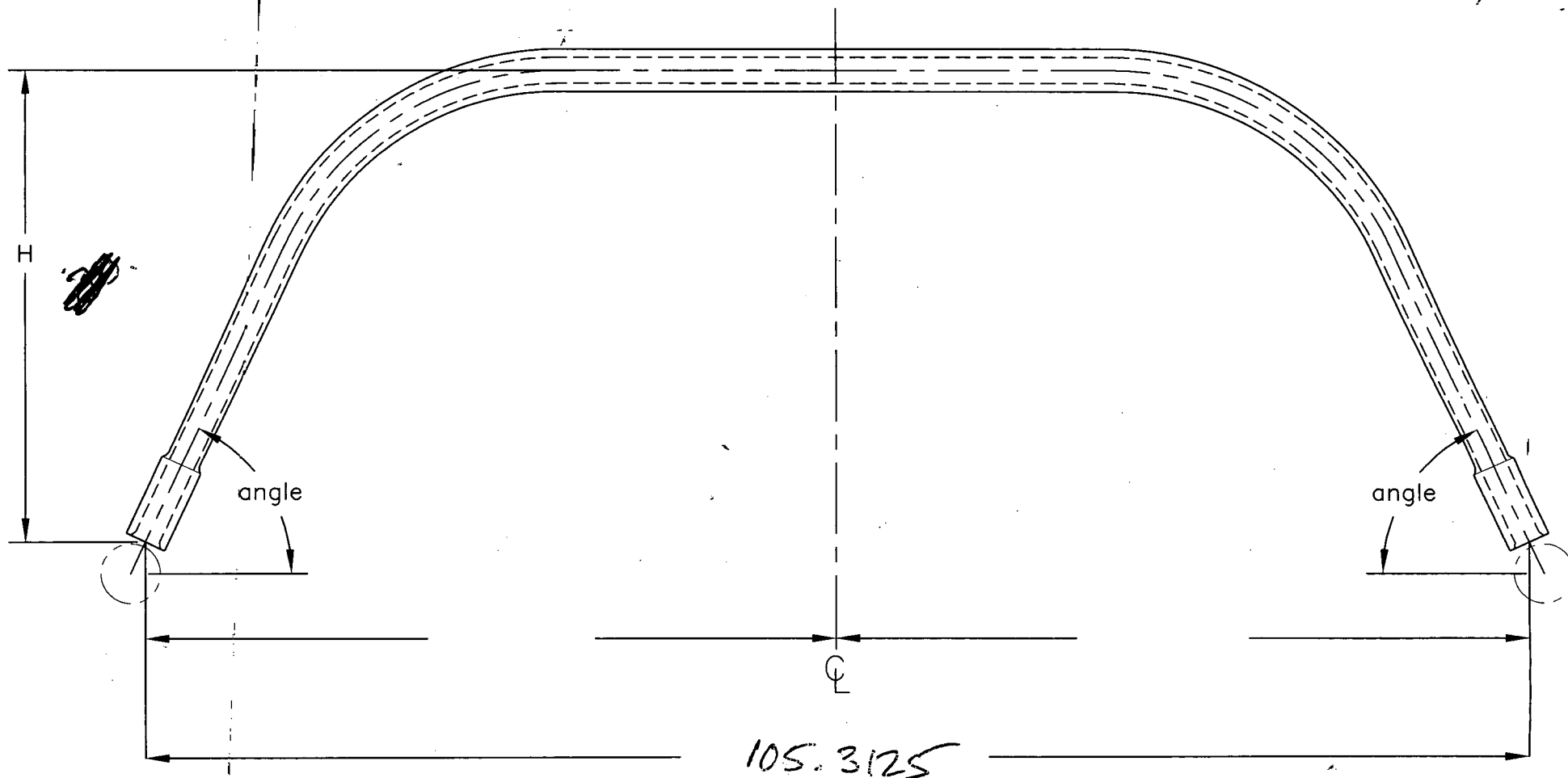
1/1
3
2
1

100
100
100
100

Aug 15

29.7.52


30.7.50

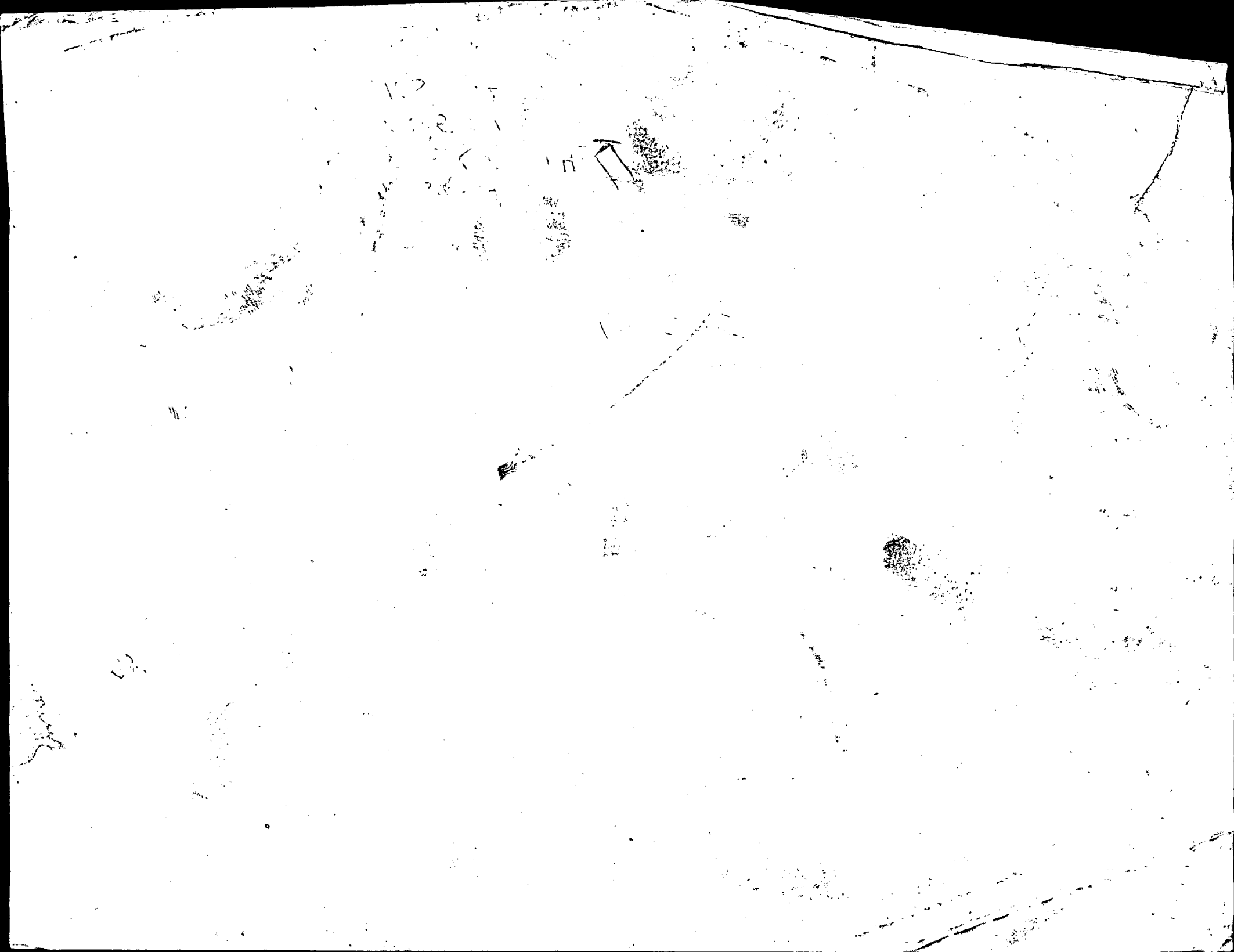


DATE: 06-06-29
 DESCRIPTION: 205-596-107
 BATCH NO: 23103
 DRAWING: 205-596-107
 H: 29.8 ✓
 1/2 SPAN: 52.5 ±.1
 TOTAL SPAN: 105 ±.2
 ANGLE: _____

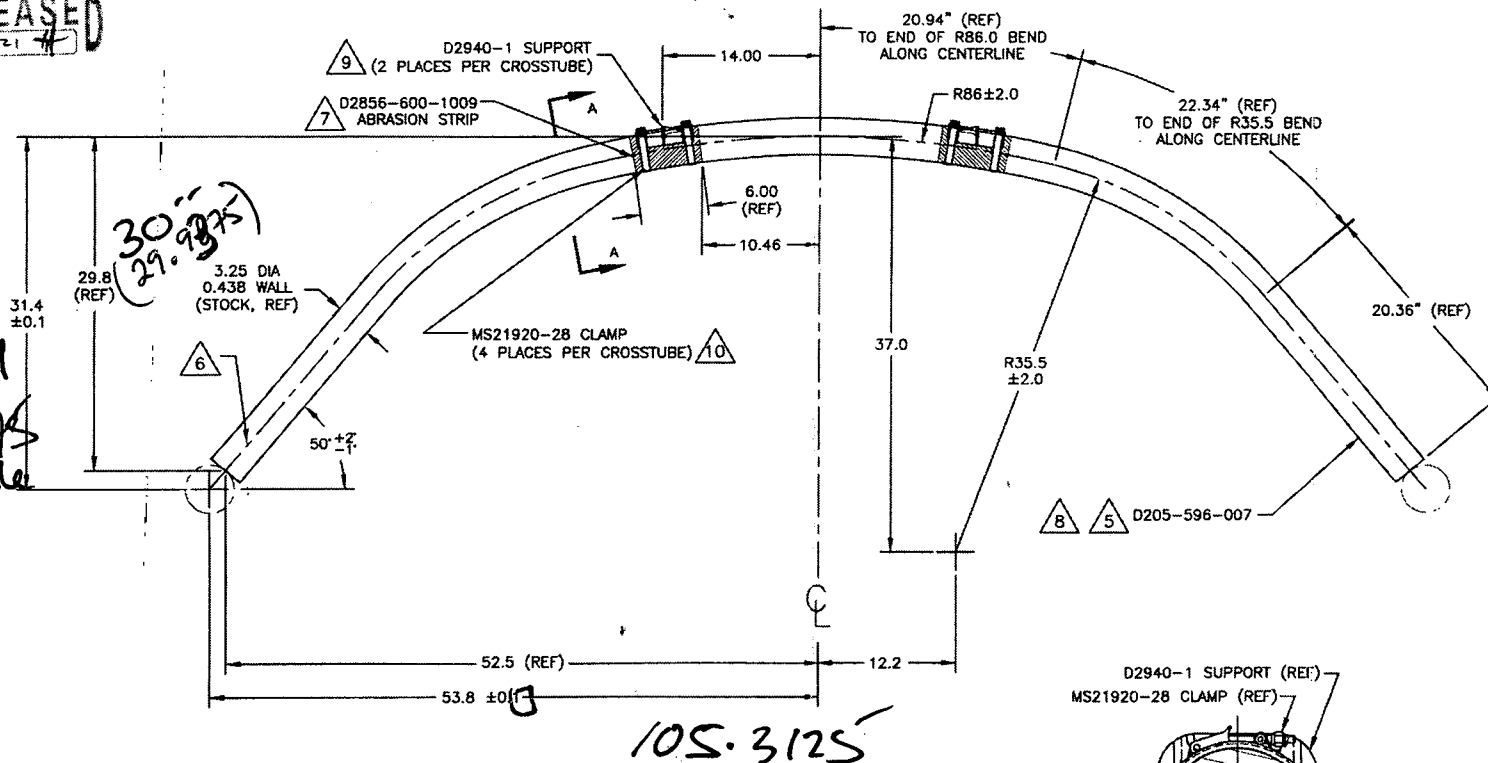
31.4 ✓

Re-check
 - Prior to shipping

 06-06-29

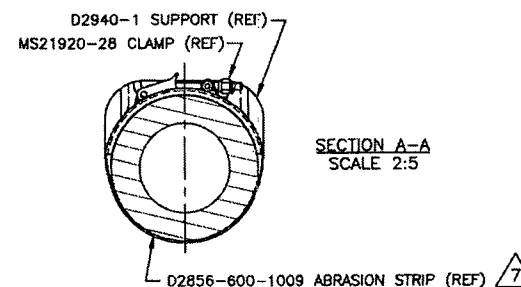


RELEASED
02.11.20



GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) MATERIAL: MANUFACTURE FROM D6008-180
FINISHED LENGTH = 127.28
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) BEND PROGRESSIVELY WITH A MINIMUM OF 3 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 6) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS
- 7) INSTALL D2856-600-1009 ABRASION STRIP WITH A 0.13 (REF) GAP ON BOTTOM SIDE OF CROSSTUBE, CENTERED OPPOSITE D2940-1 SUPPORT, PER QSI 035
- 8) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 9) SEAL EDGES OF SUPPORTS USING SIKAFLEX-241/-291 SEALANT (OPTIONAL)
- 10) TORQUE CLAMPS 80 TO 100 IN-LB



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A		02.11.20	NEW ISSUE
DESIGN	✓	DRAWN BY	DART
CHECKED	✓	APPROVED	DART
DATE	02.11.20	DRAWING NO.	D205-596-107
		TITLE	CROSSTUBE AFT EXTENDED
		REV. A	SHEET 1 OF 1
		SCALE	1:10

REFERENCE ONLY

1000000
1000000
1000000

1000000

1000000